

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017082**Date Inspected:** 29-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

**ULTRASONIC TESTING**

ZPMC NWIT: 06799

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as OBG 13CW. The weld designations are as follows:

SEG3015A-002, 003, 005, 007

This QA Inspector randomly observed the following work in progress.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201215 performing the Flux Cored Arc Welding process on weld 002 located at PCMK AP3014. ABF QA Mr. Shao Jian Yuan was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2132.

# WELDING INSPECTION REPORT

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 069089 performing the Flux Cored Arc Welding process on weld 007 located at PCMK VP3016A-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044774 performing the Flux Cored Arc Welding process on weld 006 located at PCMK VP3017A-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044795 performing the Flux Cored Arc Welding process on weld 026 located at PCMK VP3004A-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F) Repair-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045270 performing the Submerged Arc Welding process on weld 008 located at PCMK SEG3014-008. ABF QA Mr. Lv Yun was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

This QA Inspector observed ZPMC personnel performing Magnetic Particle testing on bottom plate splice weld of OBG segment 13AW. The weld number identified as SEG3013AC-001.

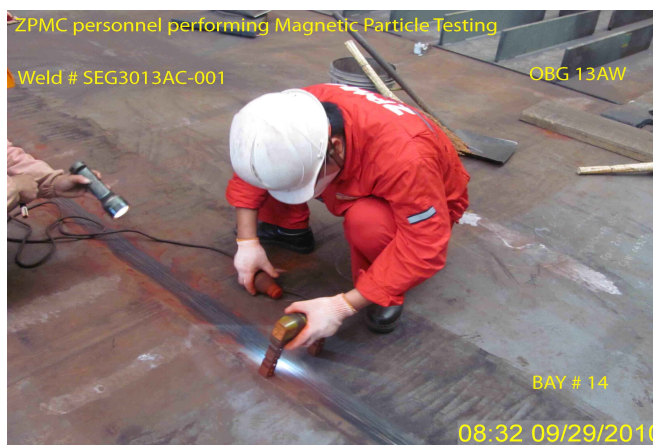
## ULTRASONIC TESTING

ZPMC NWIT: 06793

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as OBG 13BW & 13AW. The weld designations are as follows:

SEG3013AC-003; SEG3014A-003, 004, 005; SEG3014N-001, 002

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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## WELDING INSPECTION REPORT

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### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art
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QA Reviewer
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